

Order ID 84091 -1

84091

Page 1

Wednesday, May 02, 2012 1:12:13 PM

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 5/2/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date: 12-05-2 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr if necessary

304 .063

B12-5-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12 5-4

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Split 1/1

count x60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/2/2012 **Start Qty:** 50.00

50

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

140

0.00

140

Large Fab

0.00

Large Fab

Memo

Large Fab

Qty	Description	Batch A/R	2059B Hardcoat
1/21/802	1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary		

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ FAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 84091

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Wednesday, May 02, 2012 1:12:14 PM

Item ID: D3537-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearpad
 Start Date: 5/2/2012 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 5/8/2012 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				442			
170 *170* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 11:00 FINISH TIME: 11:30	0.00 0.00				42x			m/f 12/05/30
180 *180* QC Quality Control	QC3- Inspect Par: Finish Memo	0.00 0.00				42x			all 12/05/30

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop *NS2*

Start Date: 5/2/2012 **Start Qty:** 50.00

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Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 50.00

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Reference:

Run Start *NR1*

Approvals: _____ Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Identify as per dwg & Stock Location:

0,00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/5/30 ~~78~~

MF
12-05-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 02, 2012 1:12:19 PM

Page 1

Work Order ID: 84091

84091

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

94.3720

0.106

5.578947

(60)

7

M304S16GA

**

304/316 Sheet .063

1812515

Location

Loc Qty

Loc Code

MAT020

94.372

120866

14.246

120877

80.126

121625

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

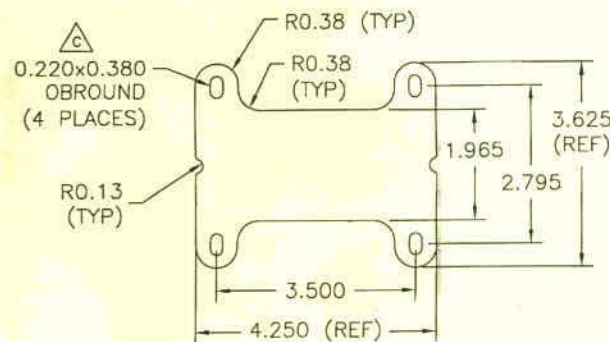
SUBJECT TO AMENDMENT

WITHOUT NOTICE

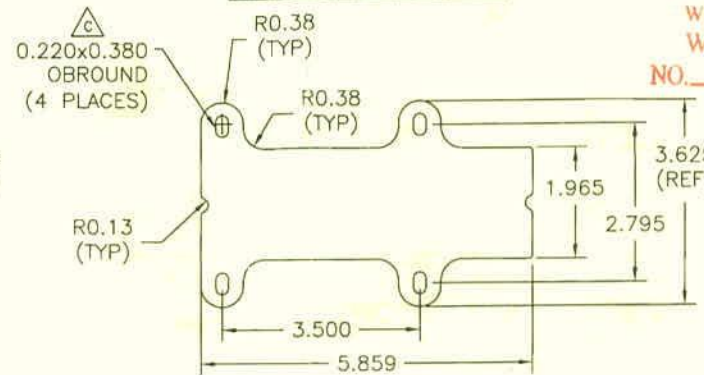
WORK ORDER

NO. 84091

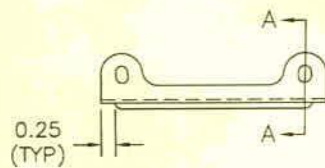
D3537-1F FLAT PATTERN



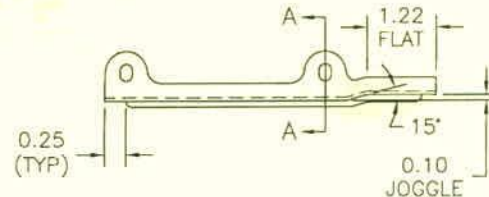
D3537-3F FLAT PATTERN



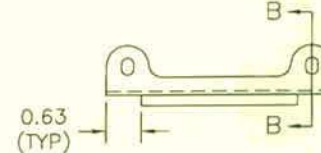
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



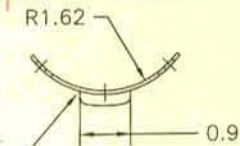
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

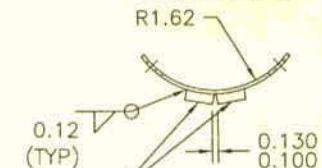
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B

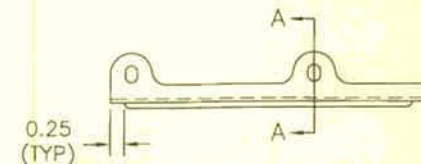


D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

UNDER REVIEW
11/10/11
OK of 11/11/11

RELEASED
07-05-08
per ECN 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	4	DRAWING NO. D3537
DATE	07.04.13	TITLE WEARPAD
APPROVED	4	REV. C SHEET 1 OF 1 SCALE 1:2

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